

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017572**Date Inspected:** 06-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 11**

This QA Inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joint BK004A3-018-010, 002 located on PCMK OBG BK004A3-018. Welder was identified as 040704. QC was identified as ZPMC CWI Qiu Wen (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Shao Hai Lang (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2231-TC-U4c-F.

FCAW welding of weld joint BK004A5-018-008, 002 located on PCMK OBG BK004A5-018. Welder was identified as 054460. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2231-TC-U4c-F.

SMAW welding of temporary transverse stiffener to deck plate located on PCMK OBG BK004A1-017. Welder was identified as 201500. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2112.

**Bay 10**

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## WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress in Bay 10:

Heat straightening of PCMK's OBG BK004-A1~A5-063~067, respectively. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the heat straightening and recording data was ZPMC QC Yu Zhi Lai (QCA2), who was not a CWI. Heat treatment observed by this QA Inspector and recorded by QCA2 appeared to comply with HSR1(B)-9343 as presented to this QA Inspector by QCA1.

### Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers' lift 3 were connected and positioned vertically on a base pedestal at end of the Heavy Dock. East, south, west, and north towers, lift 4 were positioned on top of east, south, west, and north towers, lift 3, respectively, on the Heavy Dock. ZPMC workers were match drilling 33mm holes, using magnetically attached drill presses, at previously scored holes in inner strut webs, at south and west towers, skin A, 119M level. The ZPMC 1300 ton floating crane was moored to the Heavy Dock and sitting idle.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford, William	QA Reviewer
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